

shp May 4th

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 04/05/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/13 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100 *100* DOCUMENT CONTROL 0.00

DC Memo 0.00
Document Control Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110 *110* Large Fab 0.00

Large Fab Memo 0.00
Large Fab 1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/R Aluminum Rod 119185
120169

3-Grind End Plate flush

Schultz H for MLJ 12-4-25
10

10 8 ll 12-04-14

Ae
12-04-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 2

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC9- Inspect visual per QSI004- Fusion Welds Quality Control	0.00				10	0		RF 12-04-15
130 *130* QC	QC5- Inspect part completeness to step on W/O Quality Control	0.00							12-04-14 (10)
140 *140* HandFinish	Chemical Conversion Coat per QSI005 4.1 Hand Finishing	0.00				X10			Ac 12.04.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 3

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

180

Large Fab

0.00

180

Large Fab

Memo

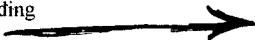
0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding



4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod 119185

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10
XO

Ø

ll
12-04-16

10
XO

Ø

ll
12-04-16

~~ll
12-04-16~~

ll
12-04-17

ll
12-04-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 4

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Quality Control

5.7/07/18

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Quality Control

5.7/07/18

(XO)

WY

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Hand Finishing

Memo

0.00

DRK/M-H
12-4-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 5

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

220

Powdercoat

Powder Coating

M121134

Memo

8-30 0.00
3200F
9-00

10X ✓ M-F
12/04/20

230

Wing Walk as per dwg QSI005 4.4 Batch 120902 0.00

230

HandFinish

Hand Finishing

Memo

0.00

10 ✓ ② 12/04/24

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

10 ✓ 12/24-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81297

March-12-12 4:42:12 PM

81297

Page 6

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Ins.
Stamp**

250

Pick Kit

0.00

250

Packaging

Memo

0.00

10

12/04/25 JB

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

0.00

5.2/4/26

(T-10)
64

270

Packaging

0.00

270

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-591-311
Location: 1A11

0.00

Rev B

QD

12/11/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order-ID 81297

March-12-12 4:42:12 PM

81297

Page 7

Item ID: D350-591-311

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop

NS2

Start Date: 12/03/2012 **Start Qty:** 10.00

10

Cust Item ID:

Required Date: 04/05/2012 **Req'd Qty:** 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Quality Control

Memo

0.00

12/4/30 JJ

12/4/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:16 PM

Page 1

Work Order ID: 81297

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

81297
D350-591-311

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22 New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	10.0000	1	10			**

D3272-1

Step

Location	Loc Qty	Loc Code
ST <u>B81311</u>	-10	
WA	20	
	10	

D3067-1

D3067-1

End Plate

Manufactured No

110 Each 178.0000

**

10

10

10

10

10

D3219-1

D3219-1

Plate

Manufactured No

110 Each 80.0000

**

20

Location	Loc Qty	Loc Code
WA016 <u>B82059</u>	80	
73410	12	
77674	6	
78763	62	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:16 PM

Page 2

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D3066-1

Manufactured No

180

Each

66.0000

2

20

**

~~B81968 (x20) Ae 12.04.16~~

D3066-1

Spacer

Location Loc Qty Loc Code

WA 66
78605 66

MS20600-AD4W4

Purchased No

180

Each

2,478.000

16

160

**

~~M121340 (x160) Ae 12.04.16~~

MS20600-AD4W4

Rivets

Location Loc Qty Loc Code

ST321 2473
116188 59
117364 253
117601 200
117885 195
118840 1089
119860 30
119883 155
120308 72
120769 420
WA018 5
116712 5

D3065-041

Manufactured No

180

Each

44.0000

1

10

**

~~B78798 (x10) Ae 12.04.16~~

D3065-041

Step Leg Assembly Hi

Location Loc Qty Loc Code

WA 44
66149 0
78799 40
79336 1
79419 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:16 PM

Page 3

Work Order ID: 81297***81297***
D350-591-311**Parent Item:** D350-591-311**Parent Item Name:** Heli-Access-Step, Long LH**Start Date:** 12/03/2012**Required Date:** 04/05/2012**Start Qty:** 10.00**Required Qty:** 10.00

D3067-1

Manufactured

No

180

Each

178.0000

1

10

**

*12-04-17****D3067-1***

End Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA	152	
78608	92	
<u>80881</u>	60	<u>10</u>
WA016	26	
67582	2	
68214	1	
79607	23	

AN3-35A

Purchased

No

250

Each

147.0000

2

20

**

*121068**JB**SP****AN3-35A****S**NO Bolt*

D3235-1

Manufactured

No

250

Each

145.0000

2

20

**

*JB**SP****D3235-1****S**WD*

Mounting Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST353	147	
120187	47	
120644	50	
120717	50	

D3278-041

Manufactured

No

250

Each

1.0000

1

10

**

*78787**JB**SP****D3278-041****S**WD*

Support Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST481	1	
78794	1	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:16 PM

Page 4

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416

NAS1149D0463J Purchased

No

250

Each

14.0000

16

160

**

121255 JB

S *AN960.ID416*

Washer

AN960JD516

NAS1149D0563J Purchased

No

116289

250

Each

0.0000

4

40

**

118614 JB

S *AN960.ID516*

Washer

AN5-36A

Purchased

No

250

Each

162.0000

2

20

**

JB

S *AN5-36A*

Bolt

D2618

Manufactured

No

250

Each

304.0000

2

20

**

JB 120187

S *D2618*

Bushing

Location

Loc Qty

Loc Code

ST340

162

120187

112

120731

50

ST012

304

76130

2

78537

102

80474

200

8778537
12X80474

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:17 PM

Page 5

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3

Manufactured No

250

Each

187.0000

4

40

✓

**

81558

JR

S
Lug
x0
D2230-3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST480	187	
53881	4	
70973	1	
80009	182	

D2856-400

Manufactured No

250

f

202.0445

1.2

12

✓

**

JB

JB

D2856-400

Abrasion Strip

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST409	202.0445	
63735	0.6696	
68076	0.3149	
71164	8.46	
79551	192.6	

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250

Each

3,226.000

2

20

✓

**

121349

JB
12/04/2012

S
Nut
MS21042L3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3226	
117441	16	
117885	32	
118451	5	
118927	3	
119017	2990	
119075	180	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-12-12 4:42:17 PM

Page 6

Work Order ID: 81297

81297

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 12/03/2012

Required Date: 04/05/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

1,367.000

8

80

✓

**

JB

AN4-13A

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	1367	
119449	59	
120187	408	
120422	500	120422
120770	400	

MS21042L5

Purchased

No

250

Each

1,622.000

2

20

✓

**

JB

MS21042L5

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	1622	
116105	5	
116548	43	
117611	42	
118179	32	
119109	1500	119109

MS21042L4

Purchased

No

250

Each

3,831.000

8

80

✓

**

JB

MS21042L4

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3831	
117441	51	
117601	157	
118451	133	
119017	200	
119075	3290	119075

AN960JD10

NAS1149D0363J Purchased

No

250

Each

0.0000

4

40

✓

**

JB

AN960JD10

Washer

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>QP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. E SHEET 1 OF 2
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04-*ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 81297 MLJ
12/03/13

Dart Aerospace Ltd

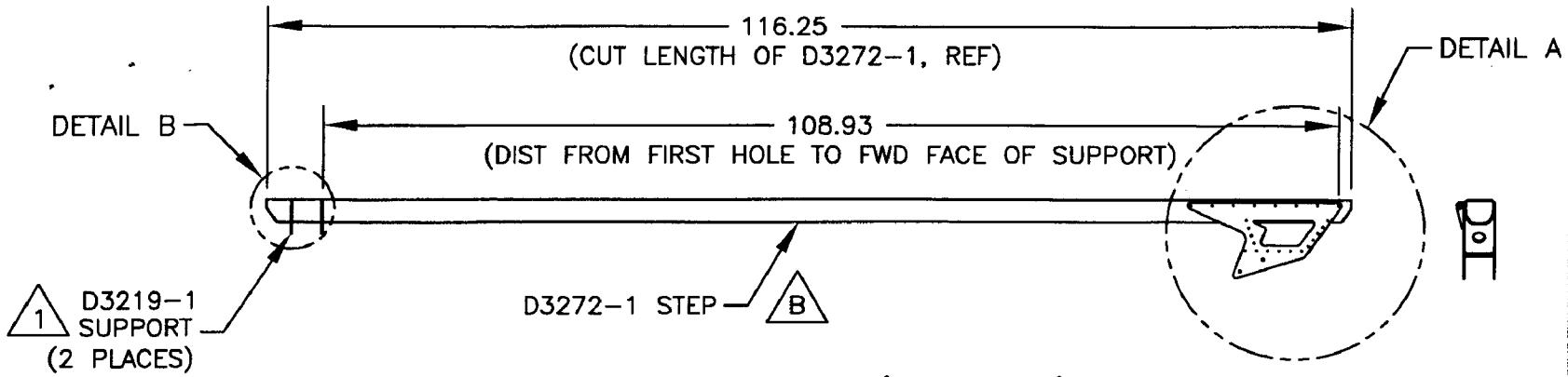
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

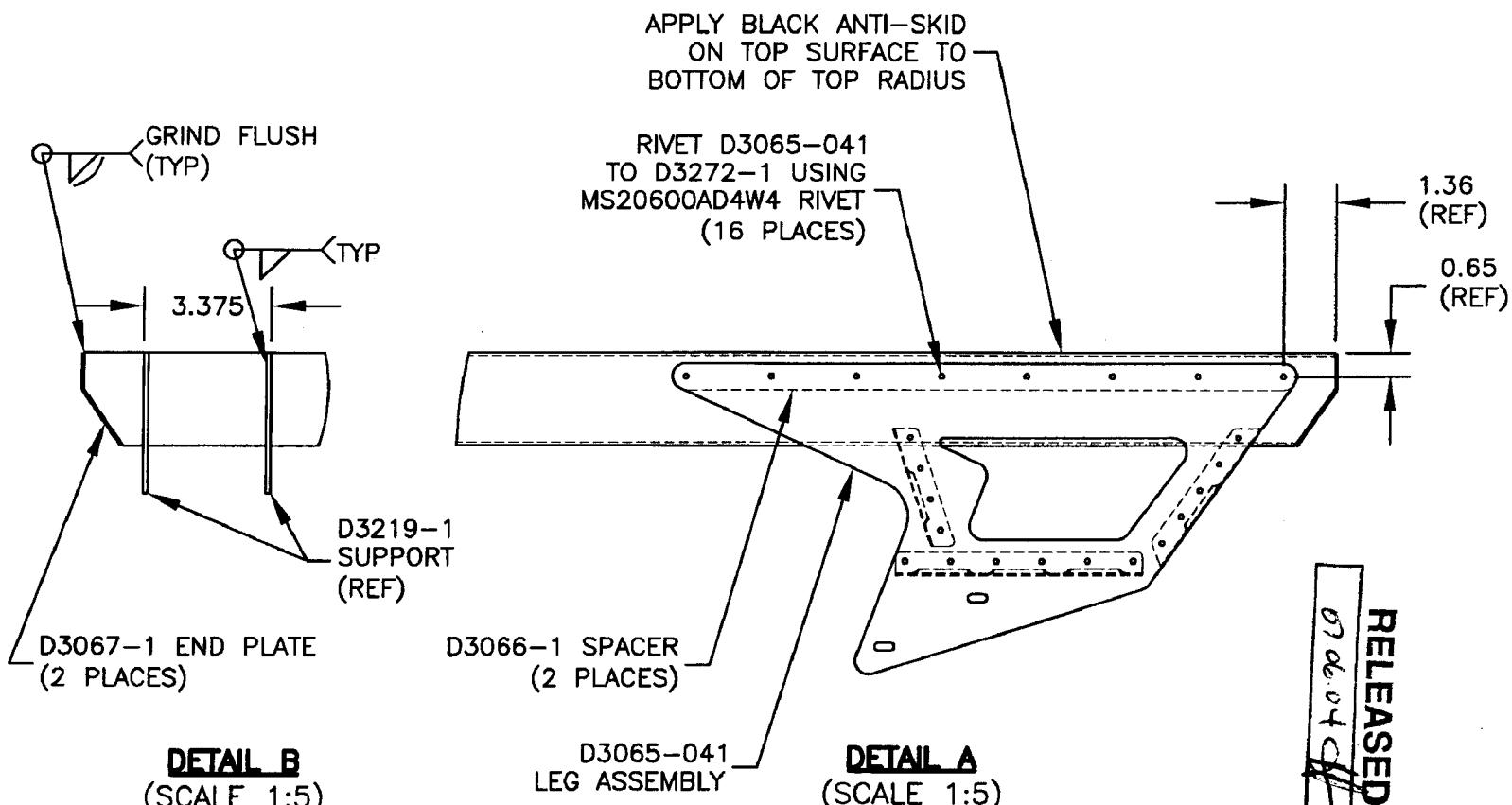
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

81297



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

DESIGN	DRAWN BY	DART AEROSPACE LTD
Q	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
ce		D3272
DATE		TITLE
07.05.18		STEP ASSEMBLY, LH LONG
REV. E		SCALE
		1:2C

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

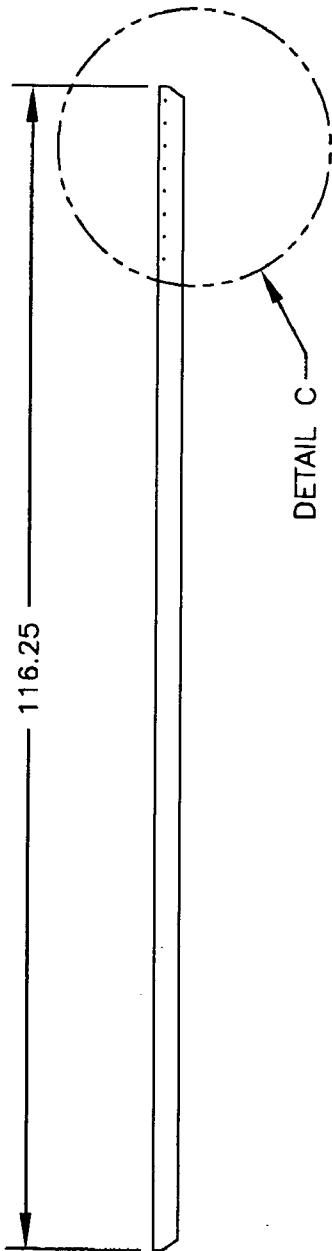
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

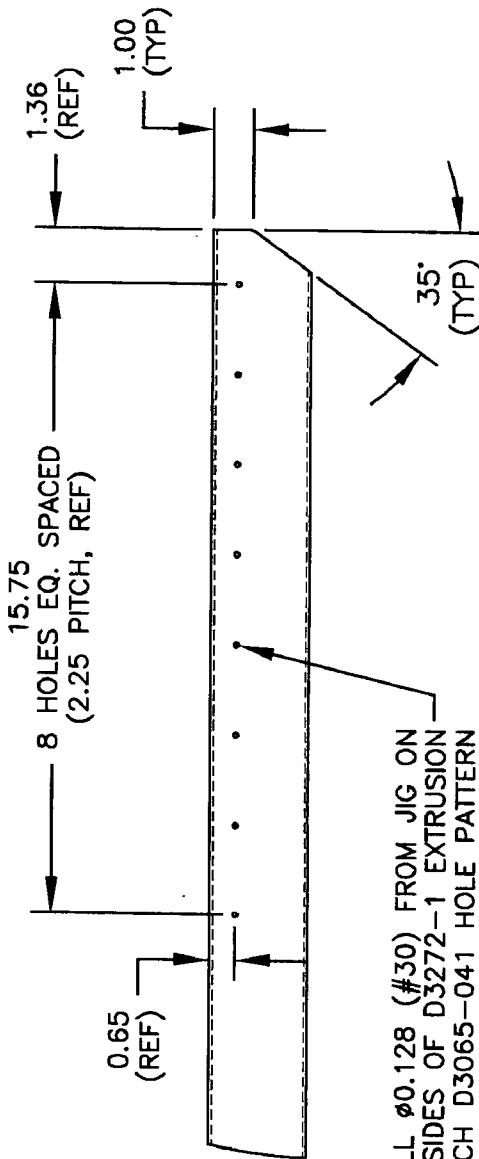
DART

DESIGN <i>QP</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>ST</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20



B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

E1297



DETAIL C
(SCALE 1:5)

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ Long Step - High Skid, LH
	X							D350-591-212	Heli-Access-Step™ Long Step - High Skid, RH
		X						D350-591-213	Heli-Access-Step™ Short Step - High Skid, LH
			X					D350-591-214	Heli-Access-Step™ Short Step - High Skid, RH
				X				D350-591-215	Heli-Access-Step™ Short Step - Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ Short Step - Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ Long Step - High Skid, LH
							X	D350-591-312	Heli-Access-Step™ Long Step - High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	-4-	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
							1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10~	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.